

Work Order ID 117264

April-30-14 2:48:15 PM

\*117264\*

Page 1

Item ID: D5046-3

Revision ID:

Item Name: Co-Pilot Collective Head

Start Date: 4/30/14 Start Qty: 12.00

Required Date: 5/02/14 Req'd Qty: 12.00

Reference: rework

Accept

\*N9000040100\*

Setup Start \*NS1\*

Stop \*NS2\*

Cust Item ID:

Customer:

Approvals:

Process Plan: *W*

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D5046

A

105

\*105\*

Large Fab

Large Fab

Memo

PULL FROM STK:  
12 X D5046-3 B116452

fill holes with weld - grind smooth both sides

0.00

0.00

*12* *12* *145-1*

115

QC10- Inspect visual per QSI004- ground welds

\*115\*

QC

Quality Control

Memo

0.00

0.00

*(12)* *140502* *DAS*  
*9*  
*9-89*

130

\*130\*

Mill Conv

Conventional Milling Machine

Memo

PULL FROM STK:  
12 X D5046-3 B116452  
REWORK PER DRWG REC'D BY MIKE P

0.00

0.00

*140503* *14/05/02* *9* *0* *1410503*

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Page 2

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Start Date: 4/30/14 Start Qty: 12.00

Required Date: 5/02/14 Req'd Qty: 12.00

Reference: rework

Accept

\*N900040100\*

Setup Start

\*NS1\*

Stop

\*NS2\*

Cust Item ID:

Customer:

Approvals:

Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_

Tooling:

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Run Start

\*NR1\*

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

140

QC2- Inspect parts off machine FAI/FAIB

0.00

\*140\*

QC

Memo

0.00

Quality Control

9 0 14-05-03

150

QC8- Inspect parts - second check

0.00

\*150\*

QC

Memo

0.00

Quality Control

9 0 14-05-05

160

Identify as per dwg & Stock Location: W/A 002

0.00

\*160\*

Packaging

Memo

0.00

Packaging

RE-IDENTIFY USING NEW B/N

9 0 14-5-6

Work Order ID 117264

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\*117264\*

Page 3

Item ID: D5046-3

Revision ID:

Item Name: Co-Pilot Collective Head

Start Date: 4/30/14 Start Qty: 12.00

Required Date: 5/02/14 Req'd Qty: 12.00

Reference: rework

Accept

\*N900040100\*

Setup Start \*NS1\*

Stop \*NS2\*

Cust Item ID:

Customer:

Approvals: Process Plan: Date:

QC: Date:

Tooling: Date:

SPC (Y/N): Date:

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/  
Work Center ID

170

\*170\*

QC

Quality Control

Operation  
Description

QC21- Final Inspection - Work Order Release

Memo

Set Up/  
Run Hours

0.00

0.00

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

14/5/17

14-05-06

# Picklist Print

April-30-14 11:52:11 AM

Page 1

Work Order ID: 117264

**\*117264\***

Parent Item: D5046-3

**\*D5046-3\***

Parent Item Name: Co-Pilot Collective Head

Start Date: 4/30/14

Required Date: 5/02/14

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP REV. A NEW ISSUE JFS 14/04/15 VERIFIED BY: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D5046-3		Manufactured		No			Each	0.0000		12			
<b>*D5046-3*</b>									<b>**</b>				
Co-Pilot Collective Head													

B116452 h

## List Lots

April-30-14 8:47:50 AM

Page 1 of 1

Criteria : Item ID: d5046-3 All Locations All Warehouses All Quantity

Item ID Item Name	Warehouse ID Location ID	Lot Number	Last Trans Date	Lot Qty	Shelf Life Dt	Type Code	Comments
D5046-3	Main Warehouse	116452	4/28/14	12.0000		QC21	
Co-Pilot Collective Head	WA002						
Total:				12.0000			

117264  
L



8

7

2

1

D

D

Ø0.63

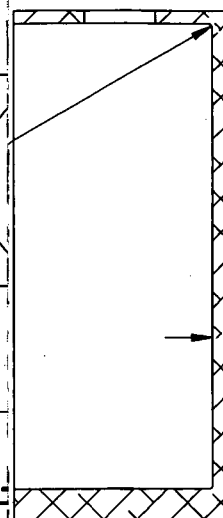
0.83

0.60

3.80

**VIEW F-**

B7-7

0.10  
TYP**SECTION H-H**

2-7

B

B

A

A

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.73 lbs
- 8) ENGRAVE "DART" LOGO AS SHOWN 0.003-0.005

**DART AEROSPACE USA, INC.**

KENT, WA

DRAWING NO.

**D5046**

REV. A

SHEET 8 OF 12

TITLE

**CO-PILOT COLLECTIVE HEAD**

SCALE

NTS

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8

7

2

1

8 7 6 5 4 3 2 1

D

D

C

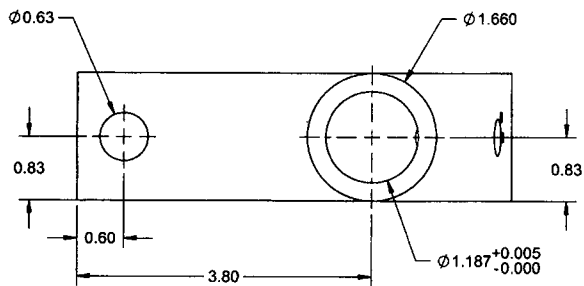
C

B

B

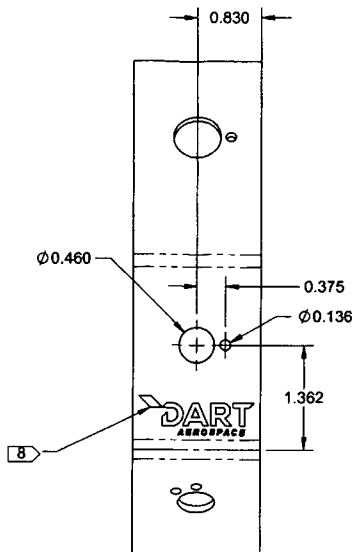
A

A



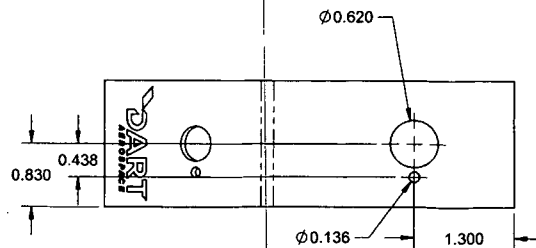
**VIEW F-F**

B7-7



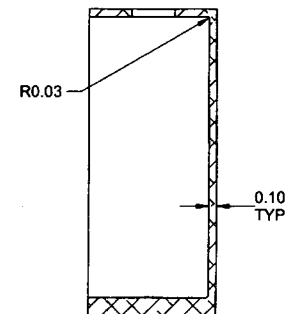
**VIEW G-G**

D6-7



**VIEW H-H**

D3-7



**SECTION H-H**

C2-7

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.73 lbs
- 8) ENGRAVE "DART" LOGO AS SHOWN 0.003-0.005 DP

**D5046-3 CO-PILOT COLLECTIVE HEAD (212)  
DETAIL VIEWS**

APPROVED

DESIGN	VS	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	VS	KENT, WA	
CHECKED	DC	DRAWING NO.	REV. A
MFG. APPR.	JFS	D5046	SHEET 8 OF 12
APPROVED	HS	TITLE	SCALE
DE APPR.	D9	CO-PILOT COLLECTIVE HEAD	NTS
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**RELEASED**  
2014-04-04  
JMP

8 7 6 5 4 3 2 1